

Work Order ID 111669

111669

Page 1

January-17-14 10:11:46 AM

Item ID: D206-642-541

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 1/17/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/28/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MCS Date: 14-01-17 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3274-041	E
-----------	---

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541 CHG004

N/A MCS 1404-03

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Item ID: D206-642-541

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 1/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/28/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

VERIFY AND INSPECT THE MATERIAL PRIOR TO USE

1- remove fwd indexing ridge as per dwg D3274. Prepare for welding

2- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch: M22324

3- grind fwd cap weld on top surface only

4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

5-Drill Aft cap pilot hole using DT8025

6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274

7 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

> - DC 14/01/22

> BE 14/01/22

> - DC 14/01/22

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Item ID: D206-642-541

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 1/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/28/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
114	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
114									
QC	Memo	0.00							
Quality Control									
116	QC10- Inspect visual per QSI004- ground welds	0.00							DAS 9 9-89
116									
QC	Memo	0.00							
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.00							
Hand Finishing									

DC 14/01/23

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Item ID: D206-642-541 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 1/17/14 Start Qty: 1.00 *1*

Required Date: 1/28/14 Req'd Qty: 1.00 *1*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.00							
Quality Control									
150	Skidtubes	0.00							
150									
Skidtubes	Memo	0.00							
Skidtubes	1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274								
	2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube								
	3-Bond web in place as per Dwg D3274 & QSI 015.								
	A/RSikaflex-291 127097								
	Sikaflex expire date: 14/08/16								
	Start: 14/01/23 Time: 4:15								
	Finish: 14/01/23 Time: 2:00								
	(Adhere for 12 hours)								

14-1-23

DC 14/01/23

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Item ID: D206-642-541

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Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 1/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/28/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control



14-1-24

170

Skidtubes

0.00

170

Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Debur

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

- DC 14/01/24

- DC 14/01/27

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Item ID: D206-642-541

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Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 1/17/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/28/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC5- Inspect part completeness to step on W/O

0.00 4.6°

180

0.00 3.0"

QC

Memo

Quality Control

1 8 14-01-27 BE

190

Skidtubes

0.00

190

0.00

Skidtubes

Memo

Skidtubes

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/RAluminum Rod M122324

BE 04-01-27

3-Grind cross bolt welds flush as per Dwg D3274.

— mm

14/01/28

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

- DE 14/01/29

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Start Date: 1/17/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/28/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC5- Inspect part completeness to step on W/O	0.00							
200									DAS
QC	Memo	0.00							9
Quality Control									9-89
210	QC10- Inspect visual per QSI004- ground welds	0.00							
210									DAS
QC	Memo	0.00							9
Quality Control									9-89
220	Pressure Wash per QSI005 4.3	0.00							
220									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch								

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1 1 1 66.9

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube

Stop *NS2*

Start Date: 1/17/14 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/28/14 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

230

0.00

230

0.00

SprayPaint

Memo

1- PRIME AS PER DWG AND QSI 005 4.2
PRIMER PRC DESOTO 515X349 BATCH: m 128 / 99

2- PAINT WHITE AS PER DWG AND QSI 005 4.2
PAINT BATCH: 126 543

240

QC14- Inspect Spray Paint

0.00

240

0.00

OC

Memo

Quality Control

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Item ID: D206-642-541

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube

Stop

NS2

Start Date: 1/17/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/28/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

0.00

250

HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

A/RN/ALPS-PROCYON M122900

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/RSikaflex-291 M122918

Sikaflex expire date: 14108

1x q 9H 4/03/10

260

QC5- Inspect part completeness to step on W/O

0.00

260

QC

Memo

0.00

Quality Control

Inspect Nut Plate & Inserts

10 14-2-10. 95 34 98

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Item ID: D206-642-541

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

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Start Date: 1/17/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/28/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

0.00

270

HAND FINISHING RESOURCE #1

HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/RSikaflex-291 14127918
Sikaflex expire date: 14108

3-Inspect for foreign objects as per QSI 024

4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/RSikaflex-291 14127918
Sikaflex expire date: 14108

12 6 11 103/11

280

QC5- Inspect part completeness to step on W/O

0.00

280

QC

Memo

0.00

Quality Control

DAS

27

9-89

1413/11

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Item ID: D206-642-541

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 1/17/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/28/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290	Identify as per dwg & Stock Location: _____	0.00	<i>PP 111669</i>						
290		0.00							
Packaging	Memo								
Packaging					DAS 06 9-13			APR 03 2014	
300	QC21- Final Inspection - Work Order Release	0.00							
300		0.00							
QC	Memo								
Quality Control									

*MLJ 1404-03**MLJ 1404-03*

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Work Order ID: 111669

111669

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/17/14

Required Date: 1/28/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.09.23 Revised per D206-642 Rev. JKI/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC IPP
 REV:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3274-041BENT		Manufactured	No			110	Each	0.0000	1	1			
D3274-041BENT				B111765				①	**			14/01/23	
Skidtube Assembly 206													
D3285-1		Manufactured	No			110	Each	45.0000	1	1			
D3285-1									**			14/01/22	
Cap													
				<u>Location</u>				<u>Loc Qty</u>					
				LG001				45					
				106171				18					
				108052				27					
D3282-041		Manufactured	No			150	Each	15.0000	1	1			
D3282-041									**			14/01/23	
Float Web (206L/407)													
				<u>Location</u>				<u>Loc Qty</u>					
				LG002				15					
				104672				5					
				108146				10					

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/17/14

Required Date: 1/28/14

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 190 Each

388.0000 12 12

D2649

Cross Bolt Spacer

BE14-01-27

Location

Loc Qty

Loc Code

LG001

388

107906

205

108633

176

90497

6

93662

1

12

D3275-1 Manufactured No 190 Each

246.0000 12 12

D3275-1

Crossbolt Spacer

BE14-01-27

Location

Loc Qty

Loc Code

LG001

246

104849

45

107892

75

109096

126

12

CR3212-4-03 Purchased No 250 Each

1,193.000 2 2

CR3212-4-03

Cherry Rivet

11/03/10

Location

Loc Qty

Loc Code

ST327

1093

114889

5

119017

700

m123265

388

st552

100

m114859

100

X 2

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/17/14

Required Date: 1/28/14

Start Qty: 1.00

Required Qty: 1.00

D3415-041 Manufactured No 250 Each 1.0000 1 1

D3415-041

Nut Plate

**

ll 1/10/3/10

Location

Loc Qty

Loc Code

ST042

1

B106195

x1

82151

1

CCR264SS3-3 Purchased No 250 Each 416.0000 2 2

CCR264SS3-3

Cherry Rivet

**

ll 1/10/3/10

Location

Loc Qty

Loc Code

ST327

416

x2

m126282

216

m126333

200

ALS4-1032-130 Purchased No 250 Each 1,817.000 78 78

ALS4-1032-130

Rivnut

**

ll 1/10/3/10

Location

Loc Qty

Loc Code

st510

1817

M128211

x78

M126109

1817

D3536-15 Manufactured No 270 Each 23.0000 1 1

D3536-15

Gasket Fwd

**

ll 1/10/3/10

Location

Loc Qty

Loc Code

FG

4

85604

2

93893

2

FP001

19

107965

6

110698

13

x1

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/17/14

Required Date: 1/28/14

Start Qty: 1.00

Required Qty: 1.00

D3536-23 Manufactured No 270 Each 16.0000 1 1

D3536-23

Gasket Center

lll 1/10/3/10

Location

Loc Qty

Loc Code

FG	2
85295	2
FP001	13
107926	13
FP002	1
107548	1

B112179

 X

D3536-35 Manufactured No 270 Each 20.0000 1 1

D3536-35

Gasket Aft

lll 1/10/3/10

Location

Loc Qty

Loc Code

FG	6
89650	2
93911	4
FP001	14
109783	14

B103306

 V

D3536-39 Manufactured No 270 Each 20.0000 1 1

D3536-39

Gasket Center Aft

lll 1/10/3/10

Location

Loc Qty

Loc Code

FG	6
85870	6
FP001	14
106124	1
<u>108021</u>	13

 X

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/17/14

Required Date: 1/28/14

Start Qty: 1.00

Required Qty: 1.00

D3535-15

Manufactured No

270

Each

19.0000

1

1

D3535-15

Stainless Steel Wearplate Fwd

ll 1/103/10

Location

Loc Qty

Loc Code

FP002

19

106776

6

110201

13

D3535-35

Manufactured No

270

Each

10.0000

1

1

D3535-35

Stainless Steel Wearplate Aft

ll 1/103/10

Location

Loc Qty

Loc Code

FG

2

94685

2

FP002

8

108053

8

D3535-39

Manufactured No

270

Each

18.0000

1

1

D3535-39

Stainless Steel Wearplate Center Aft

ll 1/103/10

Location

Loc Qty

Loc Code

FG

1

87182

1

FP002

17

101535

6

107969

11

ll

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D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/17/14

Required Date: 1/28/14

Start Qty: 1.00

Required Qty: 1.00

D3535-23 Manufactured No 270 Each

26.0000 1 1

D3535-23

Stainless Steel Wearplate Center Fwd

lll 1/10/14

Location

Loc Qty

Loc Code

FG 2

93181 2

FP001 12

107576 3

107951 9

FP002 12

110063 12

D3537-3 Manufactured No 270 Each

21.0000 1 1

D3537-3

Wearpad

lll 1/10/14

Location

Loc Qty

Loc Code

FG 8

86237 8

FP002 13

103014 13

D3537-1 Manufactured No 270 Each

21.0000 9 9

D3537-1

Wearpad

lll 1/10/14

Location

Loc Qty

Loc Code

FG 18

79833 8

88562 10

FP001 3

109600 3

13111825

0112567

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/17/14

Required Date: 1/28/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

270

Each

11,240.00

80

80

NAS1149C0332R

WASHER

**

ll 1/10/14

Location

Loc Qty

GA	1233
125654	1233
st510	10007
m126319	2107
m127306	2500
m127410	3000
<u>m127831</u>	2400

Loc Code

x80

NAS1149C0463R

Purchased

No

270

Each

500.0000

1

1

NAS1149C0463R

Washer

**

ll 1/10/14

Location

Loc Qty

FP001	21
<u>119097</u>	21
ST292	479
123248	1
123355	178
m127306	300

Loc Code

v1

D3672-1

Manufactured

No

270

Each

936.0000

2

2

D3672-1

Phenolic Washer

**

ll 1/10/14

Location

Loc Qty

FG	10
85222	10
ST060	926
103845	136
93886	522
<u>99099</u>	268

Loc Code

x2

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/17/14

Required Date: 1/28/14

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 270 Each

3,275.000 80 80

AN3C4A

Bolt

Location

Loc Qty

FG	20
122814	20
ST513	3255
125388	1835
M127410	678
M127832	742

Loc Code

ll 140310

AN4C5A Purchased No 270 Each

126.0000 1 1

AN4C5A

Bolt

Location

Loc Qty

ST355	126
122599	46
123265	30
M127410	50

Loc Code

ll 140310

D2646 Manufactured No 270 Each

33.0000 1 1

D2646

Aft Cap

Location

Loc Qty

FG	4
85848	2
90495	2
FP001	29
103306	18
107857	11

Loc Code

13110816

xl

January-17-14 10:11:51 AM

Shop Packet Print

Page 8

Picklist Print

January-17-14 10:11:51 AM

Page 9

Work Order ID: 111669

111669

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/17/14

Required Date: 1/28/14

Start Qty: 1.00

Required Qty: 1.00

D3413-1 Manufactured No 270 Each

36.0000 1 1

D3413-1

all 14031.0

O-Ring

Location

Loc Qty

ST464	36
106048	14
<u>107984</u>	20
98167	2

Loc Code

NA

January-17-14 10:11:51 AM

Shop Packet Print

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Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2800-1-240	EXTRUSION
1	1	D2848	AFT CAP
12	12	D2849	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3538-15	GASKET
1	1	D3538-23	GASKET
1	1	D3538-35	GASKET
1	1	D3538-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN860C416	WASHER
80	80	AN860C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

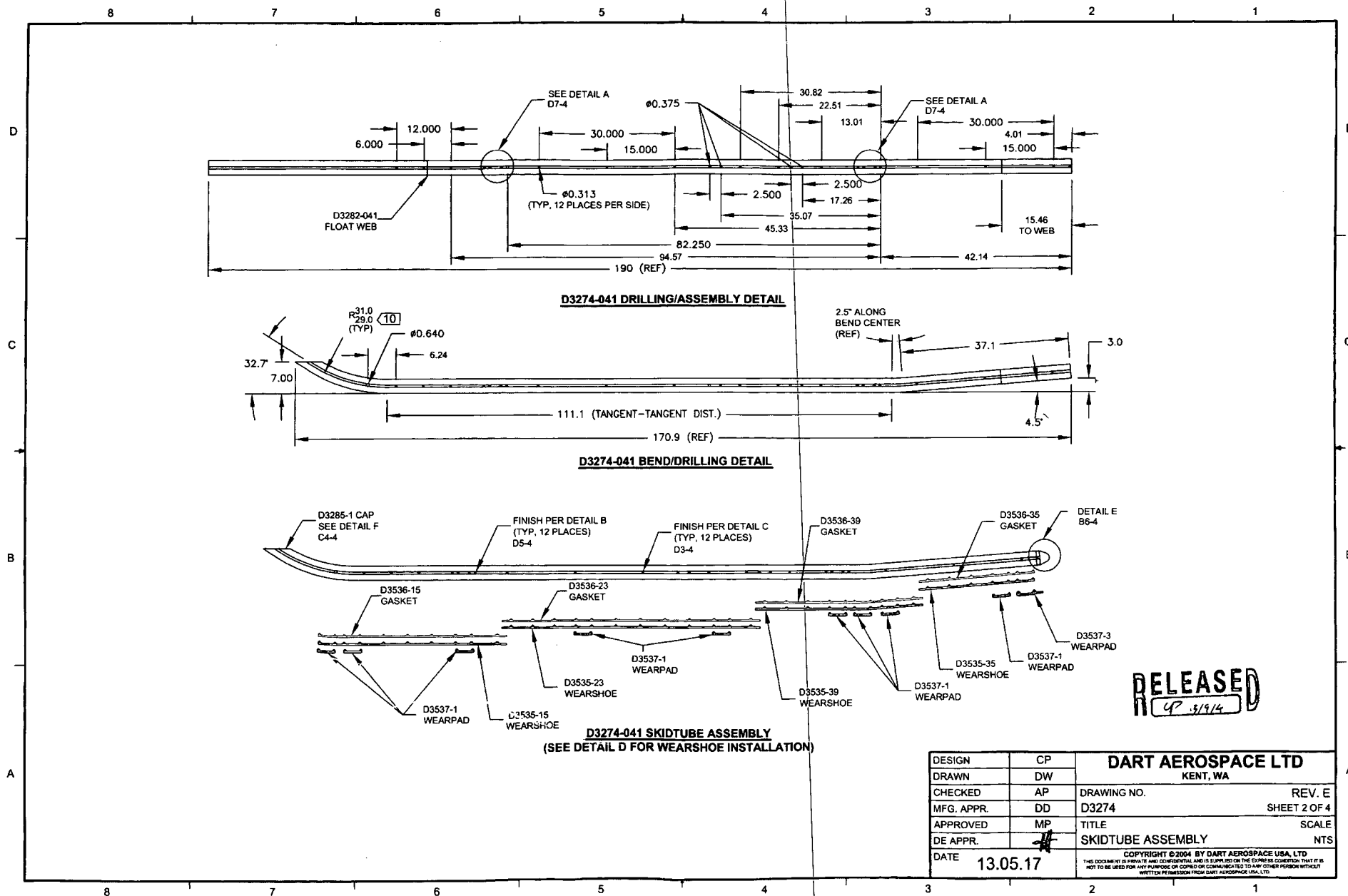
GENERAL NOTES:

- MATERIAL: N/A
- FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2 E
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES 0.005 TO 0.010 MAX
- IDENTIFICATION: N/A
- WEIGHT: 20.8 LBS
- WELDING TO BE DONE PER DART QSI 004.
- ALL HOLES DRILLED ON CENTERLINES.
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/281 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- DRILL 20.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/-281.
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS GREASE WITH WASH 'N WIPE DEGREASER.

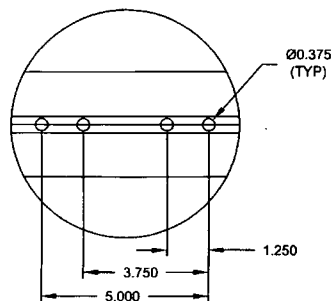
111669 MLC
1401-17

RELEASED
13/5/14
EN 18-567

E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	06.12.19
C	ADD -043: NEW INSERTS	CP	05.03.16
B	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DW	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. E
MFG. APPR.	DD	D3274	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	13.05.17	COPYRIGHT © 2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.	

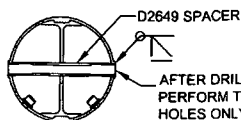


DETAIL A: DRILL DETAIL
D6-2, D3-2, D5-3, D3-3



DETAIL B
B6-2, B5-3

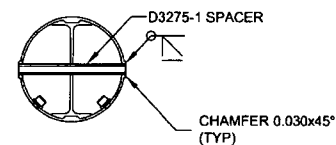
FOR Ø0.375 HOLES ONLY



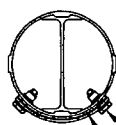
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C
B5-2, B4-3

FOR Ø0.313 HOLES ONLY

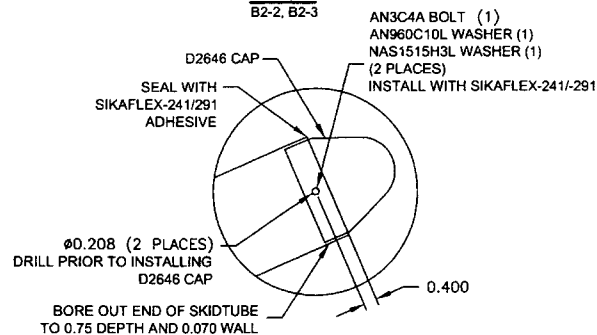


DETAIL D
A4-2, A4-3

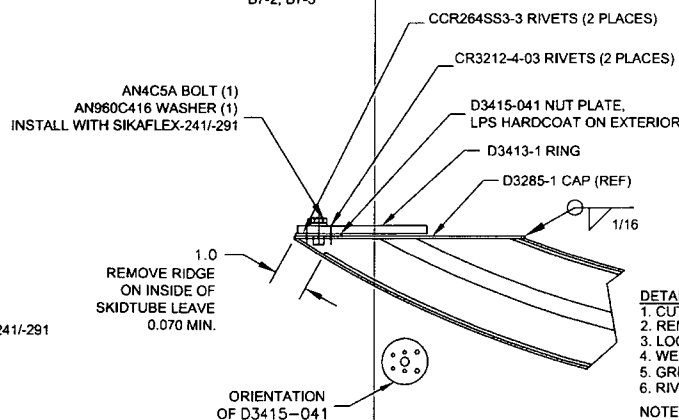


ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E
B2-2, B2-3



DETAIL F: END FINISHING DETAIL
B7-2, B7-3



DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASED
9/13/9/4

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DW	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. E
MFG. APPR.	DD	D3274	SHEET 4 OF 4
APPROVED	MR	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	13.05.17	<small>COPYRIGHT © 2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.</small>	

No. 336

**AWS D17.1/D17.1M:2010
SKIDTUBE WELDING TEST RECORD**

Name: Barclay Elliott
Job #: 103007
Part #: D206-642-151
Description: 206 skid tube
Welding Process: TIG ☒ MIG ☐
Base Material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Penetration:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Fusion:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Cracks:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Overlap (cold lap):	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Undercut:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Pin holes:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Porosity (surface):	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Coloration:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Burn through:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>

Qualifier: DAS
9
9-89

Date of Test Coupon: 13-11-14

Welder: Barclay Elliott

Date of Test Coupon: 13-11-14

The above named individual is qualified to weld in accordance with AWS D17.1/D17.1M:2010.